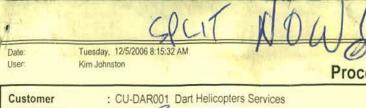
Form: rprocess



Page 1

Process Sheet

| Customer Job Number Estimate Number | : CU-DAR001 Dart Helicopters Services : 29777 - 2 : 10313 | Drawing Name | : WEARPAD | |
|-------------------------------------|---|------------------------------------|--|--|
| P.O. Number | : NIA | Part Number | : D26483 | |
| This Issue | : 12/5/2006 S.O. No. : P(A) | Drawing Number | : D2648 REV D : N/A | |
| Prsht Rev, First Issue | : NA Type : SMALL/MED FAB | Project Number Drawing Revision | : D | |
| Previous Run | : 29226 | Material | :NIA | |
| Written By | : 10 m | Due Date | : 1/5/2007 Qty : | 400 Um: Each |
| Checked & Approv | | | | |
| Comment | : Est: E 02.09.18 Re-format; Incorporated D Est Rev:F Now on Waterjot 06-08-14 | 2648-1 KJ/RF JLM | | |
| | 12/M-MCCAR-WWW.Co | JLW | | |
| Additional Product | | | | |
| | | | | |
| Job Number: | | | | |
| Seq. #: | Machine Or Operation: | Description : | | |
| 1.0 | M1010S16GA 1010/ | 1025/A21/6aA SHEET | 100000000 | |
| | | | | |
| Comme | ent: Qty.: 0.0788 sf(s)/Unit Total: 31.5000 sf(s | 3) | 1 188111 8811 1881 | |
| | 1010/1025/A21/6aA SHEET M1030LAX | | | |
| | (M1010S16GA) 22.5168 1 | 4 | | |
| | Batch: 1/11/03/21/ 1/1/ 0 | 70117 | | (406) |
| 2.0 | WATER JET FLOW | / WATER JET | | |
| | | | | |
| Comme | ent: FLOW WATER JET | | 110001100110011001100110011001 | |
| | 1-Cut as per Dwg D2648 | | | |
| | *************CUT WITH FILE D2648-1*********** | ****** | | |
| V | Dwg Rev: D 07 | 0118 | | |
| | Prog Rev: | | 1 | |
| 3.0 | 2-Deburr if necessary | CT PARTS AS THEY COME | Am 07/01/30 | (400) |
| 3.0 | INSPE | COT PARTS AS THE COME | IIIIIIIIIIIIIIIIIIIIIIIIIIIIIIIIIIIIII | |
| | m/ 07 01 | 18 | | (Goo) |
| Comme | ent: INSPECT PARTS AS THEY COME OFF MACHIN | E | | (100) |
| 4.0 | QC8 SECO | ND CHECK | | |
| | | | | |
| | ent: SECOND CHECK | | 1407/01/24 | (400) |
| 5.0 | SMALL FAB 1 SMAL | L & MEDIUM FAB RESOURC | E 1 | |
| | | | | |
| Comme | ent: SMALL & MEDIUM FAB RESOURCE 1 | NIA. | | |
| - Cojiiiii | Deburr if necessary | ha. | | A COLUMN TO A COLU |
| | | | | |

| W/O: | | | WORK ORDER CHAI | NGES | | | |
|---------|------|--|--|-------------------------|----------|-------------------------------------|--------------------------|
| DATE | STEP | PRO | CEDURE CHANGE | Ву | Date Qty | Approval Chief Eng / Prod Mgr | Approva QC Inspecto |
| | | | | | | | ы |
| | | | | | | APPEN N | 5 |
| Part No | | PAR #: | Fault Category: | | No DQA: | | 2/02/2 |
| NCR: | | W. Commission of the Commissio | ORK ORDER NON-CONFOR | MANCE (NCF | R) | | |
| DATE | STEP | Description of NC Section A | Initial Action Description Chief Eng Chief Eng | Section B Sign 8 Date | | Approval Chief Eng | Approval QC Inspector |

| DATE STEP Description of NC Section A Chief Eng Corrective Action Section B Section C Section A Chief Eng Corrective Action Description Section C Section C Chief Eng Corrective Action Description Chief Eng Corrective Action Description Section C Section C Chief Eng Corrective Action Description Section C Section C Chief Eng Corrective Action Description Section C Section C Chief Eng Corrective Action Description Section C Section C Chief Eng Corrective Action Description Section C Section C Chief Eng Corrective Action Description Section C | NCR: | | WORK ORDER NON-CONFORMANCE (N | | SE (NCR) | ₹) | | | | |
|---|-------------|---------------|-------------------------------|-----------------------|-----------------------------|-----------------------------|--|--------------|-----------|--------------|
| Section A Initial-Chief Eng Action Description Ohief Eng Section C Chief Eng QC Inspector | | 3,18 | Description of NC | - | Corrective Action Section B | | | Verification | Approval | Approval |
| | DATE | STEP | | Initial- Chief Eng | Acti | On Description Chief Eng | | | Chief Eng | QC Inspector |
| | TO SECOND | | | | | | | | | |
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| NOTE: Date & initial all entries | W. Carlotte | 1 1 1 1 1 1 1 | | | | | | | | |

NOTE: Date & initial all entries

Tuesday, 12/5/2006 8:15:33 AM Date: User: Kim Johnston **Process Sheet** Drawing Name: WEARPAD Customer: CU-DAR001 Dart Helicopters Services Job Number: 29777 Part Number: D26483 Job Number: Seq. #: Description: Machine Or Operation: 6.0 BRAKE NO NC BRAKE Comment: NC BRAKE 1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D2648-3 LARGE FABRICATION RESOURCE 1 LARGE FAB 1 7.0 Comment: LARGE FABRICATION RESOURCE 1 Description FC 07 02 14 Qty CHO3030 - MI03372 - MI03031 A/R560Hardcoat 1-Weld as per Dwg D2648 using Jig DT 8210 2-Remove any weld that penetrated through Wearpadif necessary 8.0 QC9 VISUAL WELDING INSPECTION Comment: VISUAL WELDING INSPECTION INSPECT WORK TO CURRENT STEP 9.0 QC5 Comment: INSPECT WORK TO CURRENT STEP POWDER COATING POWDER COATING 10.0 M 101 601 Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 11.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 12.0 PACKAGING Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FP17 QC21 FINAL INSPECTION/W/O RELEASE 13.0 Comment: FINAL INSPECTION/W/O RELEASE Page 2 Form: rprocess

| Dart Ae | rospace | Ltd | | | | | | | |
|---------|---------|-------------------|----------------------|------------------------------|--------|------------|-------|-------------------------------------|--------------------------|
| W/O: | | | WC | ORK ORDER CHANGES | | | | | is all |
| DATE | STEP | PRO | CEDURE CHA | NGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | | | |
| Part No | | PAR #: | Fault Categ | gory: NO | R: Yes | No DQA | A: | Date: | |
| | | | | | QA: N | I/C Closed | d: | _ Date: _ | |
| NCR: | | N A | VORK ORDE | ER NON-CONFORMANC | E (NCF | ۲) | | | |
| | | Description of NC | 1 | Corrective Action Section B | | Verific | ation | Approval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign 8 | Section | | Chief Eng | QC Inspector |
| | | | | | | | | | |
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NOTE: Date & initial all entries

Dart Aerospace Ltd

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| DATE | STEP | PR | OCEDURE CHANGE | | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | 2016 | | | | | | | | |
| ≅al ^G | 84 | | | | | | | | |
| Part No | | PAR #: | Fault Category: | NCI | R: Yes | No DQA | | Date: | |

QA: N/C Closed: ____ Date: ___

| DATE STEP Section A Initial Chief Eng Chief Eng Sign & Date Section C Ch | APOUGI Anne | Approval | Verification | | Corrective Action Section B | Description of NC | VERRODANDAV | |
|--|--------------|-----------|--------------|-----|------------------------------|-------------------|-------------|------|
| | oroval Appro | Chief Eng | | | Action Description Chief Eng | Section A | STEP | DATE |
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NOTE: Date & initial all entries

| DART AEROSPACE L | TD | Work Order: | 29777 |
|-----------------------|--------|--------------|-------------|
| Description: Wearpad | | Part Number: | D2648-3 |
| Inspection Dwg: D2648 | Rev: D | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

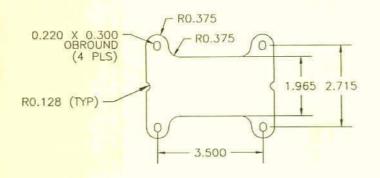
| | х | First Article | е 🔲 | Protot | уре | |
|----------------------|---------------------|---------------------|--------|--------|-------------------------|----------|
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
| 1.965 | +/-0.010 | 1.975 | 1 | | VERN | 7 |
| 2.715 | +/-0.010 | 2.715 | 1 | | vern | |
| 3.500 | +/-0.010 | 3.504 | | | VEIN | |
| 0.220 x 0.300 | +/-0.010 x +/-0.010 | 1.220V 0.300 | 1 | | VerN | |
| R0.375 | +/-0.010 | RU. 375 | 1 | | Rudius Gu | AL. |
| R0.128 | +/-0.010 | RO.128 | 1/ | | RADIUS GU | Ex. |
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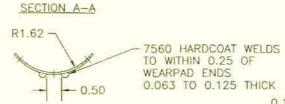
| Measured by: | We wer | Audited by: | Prototype Approval: | N/A |
|--------------|--------|----------------|---------------------|-----|
| Date: | 070118 | Date: 03/01/24 | Date: | N/A |

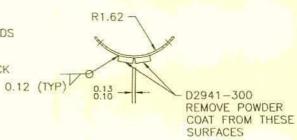
| 1 | Rev | Date | Change | Revised by | Approved |
|-----|-----|----------|-----------|------------|----------|
| | Α | 06.10.16 | New Issue | KJ/JLM | 901 |
| 1.5 | | | | - 11 | //0// |



D2648-1 FLAT PATTERN

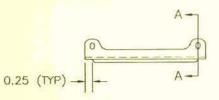




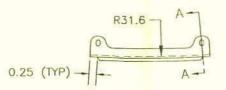


SECTION B-B

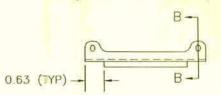




D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



(MADE FROM D2648-1)







| | BREAK ALL SHARP CORNERS 0.063 MAX | |
|---|--|---------------|
| | MATERIALO 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL | (0.063 THICK) |
| | ENISH POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005 | |
| | TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED | |
| ź | ALL DIMENSIONS ARE IN INCHES | |

| D | 99.11.17 | ADDED D2648-7 |
|----------|------------|---------------------------------------|
| С | 97.06.26 | R31.6 WAS R19.6 |
| В | 97.05.30 | ENLARGE OBROUND, 0.375 WAS 0.250 |
| A | 97.03.25 | NEW ISSUE |
| DESIGN | "RF | DART DART AEROSPACE USA, INC. |
| CHECKEN | APPROVED # | DRAWING NO. REV. D D2648 SHEET 1 OF 1 |
| DATE | 1 13 | TITLE SCALE |
| 99.11.17 | | WEARPAD 12 |

